



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3139-1
Job Sheet 169581



Part No: D3139-1

Job Qty: 4 ea

Part Name: Guard



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/14/17

Job Tracking No:

Due Date: 1/4/18

Created By: Chantal Lavoie

Type: Stock

Description:

Customer: Bell Helicopter Textron Inc (CEDWA01)

Attn: Bell Piney Flats PO Box 77045 Fort Worth, TX, 76177 USA ph:817-837-4700 fx:866-668-4852.

Note: DWG REV C IPP Rev. A New Issue Form In-house 10/11/19 DL ver:DD IPP Rev. B Water jet Added 10/11/24
DL IPP Rev C 14/01/20 Change QC2 to QC6 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	4 pcs		1/4/18	0.00	0.00	Purchasing	AT	18/01/31
140	Packaging	4 pcs		1/4/18	0.00	0.00	Packaging2	AT	18/01/31
150	QC	4 pcs		1/4/18	0.00	0.00	QC6		38
170	Packaging	4 pcs		1/4/18	0.00	0.00	Packaging3-1		9-89
180	QC21-SA	4 Ea		1/4/18	0.00	0.00	QC21		21

Part Op 140 - Receive & Inspect for Damage & Mat'l Certs
Descriptions: 150 - QC6- All purchased or subcontracted products
170 - Identify as per dwg & Stock Location:
180 - QC21- Final Inspection - Work Order Release

PO 038651 DEC 14 2017

FEB 05 2018

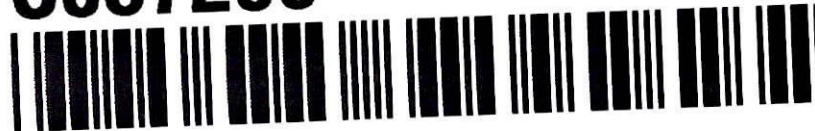
CA002

reB

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
110-Purchasing	D3139-1P	4	0	0	0

DART
AEROSPACE
S037200



Guard

PART NO: D3139-1
Original Serial #: S037200
Revision:
Operation:
Change No:

Purchasing

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Mfg Date: 01/30/18
Job No: 169581

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Guard	0.098inches + 0.004 - 0.001	0.102 0.097		
2	Guard	0.500inches ± 0.010	0.510 0.490		
3	Guard	2.060inches ± 0.030	2.090 2.030		
4	Guard	3.710inches ± 0.030	3.740 3.680		
5	Guard	0.400inches ± 0.010	0.410 0.390		
6	Guard	2.600inches ± 0.010	2.610 2.590		
7	Guard	3.000inches ± 0.030	3.030 2.970		
8	Guard	0.125inches ± 0.010	0.135 0.115		

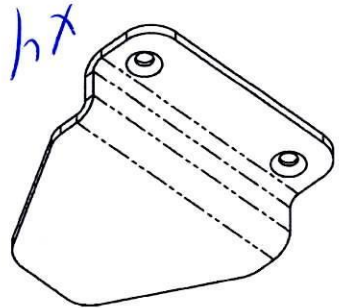
Plex 12/14/17 8:02 AM dart.lavoie.chantal

DATE		11.01.07
DESIGN	DESIGNER	
CHECKED	CHECKED BY	
APPROVED	APPROVED BY	
TITLE		GUARD
DRAWING NO.		D3139
REV. C		
SHEET 1 OF 3		
SCALE		NTR
DART AEROSPACE LTD HAMMERSBURG, ONTARIO, CANADA		

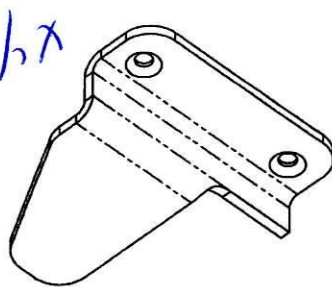
Plat Tool

RELEASED
2011-02-18

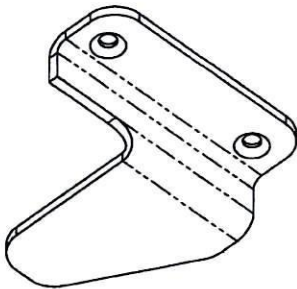
D3139-1 GUARD
(REPLACES PREMIER P/N B30-23000-237/-238)



D3139-3 GUARD
(REPLACES PREMIER P/N B30-23000-239)



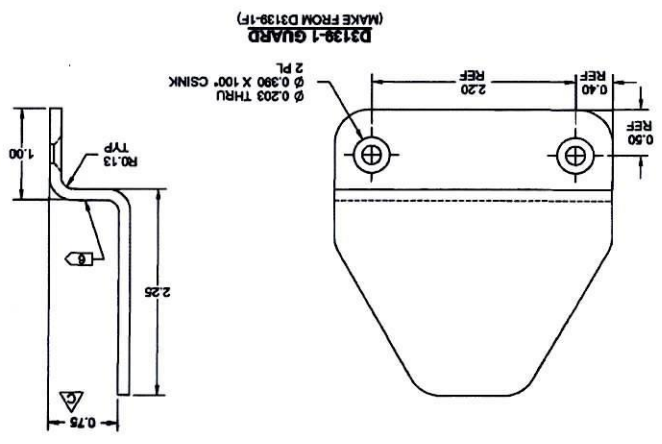
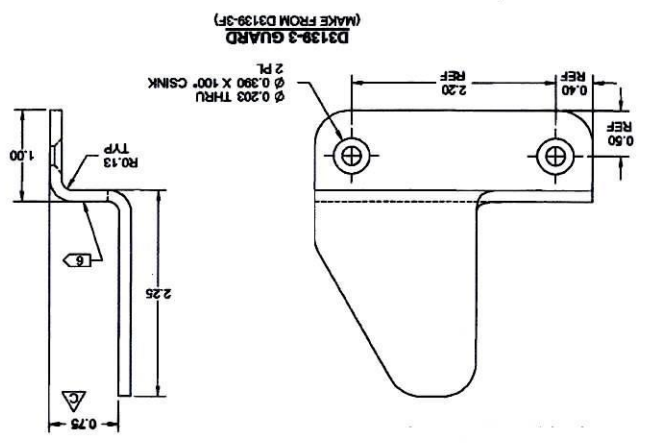
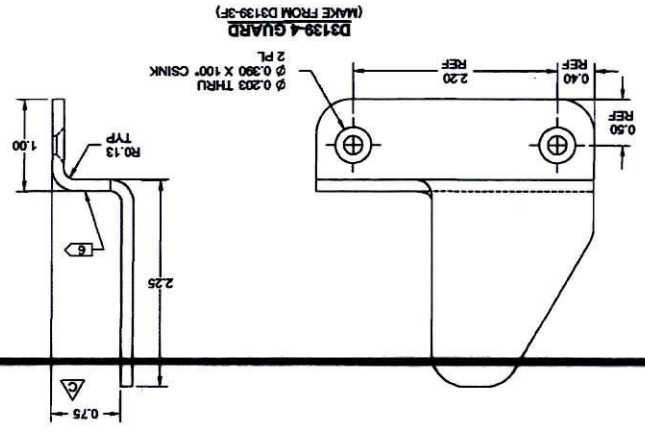
D3139-4 GUARD
(REPLACES PREMIER P/N B30-23000-240)

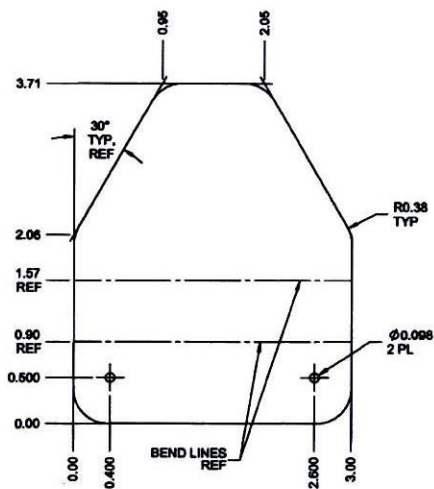


DATE	11.01.07
DESIGN	
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
TITLE	GUARD
SCALE	1:1
SHEET 2 OF 3	
REV. C	
DRAWING NO.	D3139
HAMKESBURY, ONTARIO, CANADA	
DART AEROSPACE LTD	

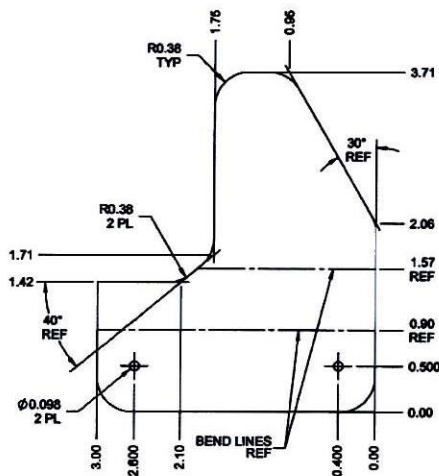
NOTES:
 1) MATERIAL: PER D3139-1F-3F
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: WITH DART PIN "D3139-X" AND "B.N. 800000"
 7) WEIGHT: 0.05 lbs

RELEASED
 2011-02-18





D3139-1F GUARD FLAT PATTERN



D3139-3F GUARD FLAT PATTERN

RELEASED
2011-02-18

- NOTES:**
 1) MATERIAL: 9034 CLEAR LEXAN SHEET (SMOOTH TEXTURE), 0.125" THICK
 REF. DART SPEC. MLEXS.125-9034-01
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 0.05 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3139	REV. C
MFG. APPR.		TITLE	SHEET 3 OF 3
APPROVED		GUARD	SCALE
DE APPR.			NTS
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